

Work Order ID 51172

August 6, 2009 10:09:29 AM



Page 1

Item ID:	D3934-041	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Clip Assembly					
Start Date:	08/06/2009	Start Qty: 6.00		Cust Item ID:		
Required Date:	08/10/2009	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan: <u>MF</u>	Date: <u>09-08-06</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3934	RevA

19

100 0.00



Waterjet
FLOW CNC Waterjet

Memo
1-Cut as per Dwg D3934
Dwg Rev: A
Prog Rev: A

2-Deburr if necessary

→ 8/09/08/07 (19)

AB 9-8-6

AB 9-8-6

110 QC2- Inspect parts off machine FAI/FAIB 0.00



QC
Quality Control

Memo

(19)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item Name: Clip Assembly

Setup Start

Stop

Start Date: 08/06/2009 Start Qty: 6.00

Required Date: 08/10/2009 Req'd Qty: 6.00

Cust Item ID:

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	2) 508/08/07			contes (49)	/		
130  Brake NC Brake NC	Memo 1- Bend as per dwg D3934	0.00 0.00	SB 09/08/17			(19)	/		
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	2) 508/08/17			(49)	/		

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Item ID: D3934-041

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Start Date: 08/06/2009 Start Qty: 6.00

Required Date: 08/10/2009 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150



Small Fab

Memo

0.00

0.00

Small Fab

1-C'sink and assemble as per dwg D3934

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

2) Sorlos/16

(K5)

170



Packaging

Packaging

Identify as per dwg & Stock Location: 136

Memo

0.00

0.00

129/8/15 (19)

09/08/18 (19)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Accept



Setup Start



Revision ID: A

Stop



Item Name: Clip Assembly

Start Date: 08/06/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 08/10/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/26 HJ

MK 09-08-24

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

August 6, 2009 10:09:29 AM

Page 1/2

Work Order ID: 51172

Parent Item: D3934-041RevA

Parent Item Name: Clip Assembly

Comments:

Start Date: 08/06/2009

Required Date: 08/10/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

150

sf

71.0990

0.1326



304/316 .040 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

71.09904737

110076

31.73

111571

39.3690474

MS21075L3

Purchased

No

150

Each

142.0000

6.0000



Nutplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

142

109068

12

109371

39

110704

37

111477

34

112314

20

~~109088~~

Ep09/08/18

~~109088~~

~~B 98-6~~

~~109088~~

~~B 98-6~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Parent Item: D3934-041RevA



Parent Item Name: Clip Assembly


Start Date: 08/06/2009

Required Date: 08/10/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD3-3  Rivet		Purchased	No			100	Each	7,856.000	12.0000			



EF 08/08/08

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

7856

1563

0

19099

4776

7681

3080

38

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DART AEROSPACE LTD		Work Order:	SI 172
Description: Clip ASSEMBLY		Part Number:	D 3934-1
Inspection Dwg: D 3934-1 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

First Article

X

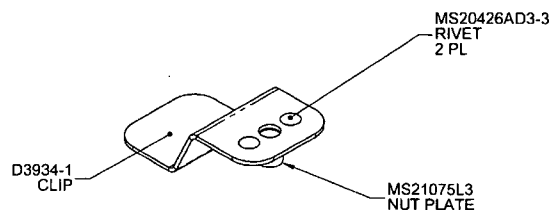
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Measured by:	B	Audited by:	S	Prototype Approval:	
Date:	9-8-6	Date:	08/08/07	Date:	1/9

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM	QTY .041	P/N	DESCRIPTION
1	X	D3934-041	CLIP ASSEMBLY
10	1	D3934-1	CLIP
20	1	MS21075L3	NUT PLATE
21	2	MS20426AD3-3	RIVET

#51172
mf
09-08-06



D3934-041 CLIP ASSEMBLY

RELEASED
09/09/16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3934-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs

A	NEW ISSUE	PH	09.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3934	REV. A
TITLE CLIP ASSEMBLY	SHEET 1 OF 2
SCALE NTS	
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W/O:		WORK ORDER CHANGES					
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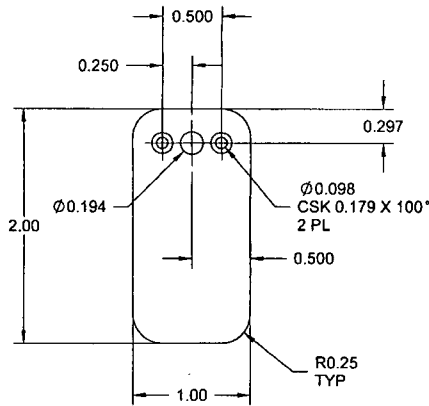
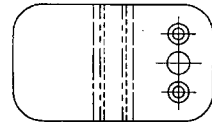
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

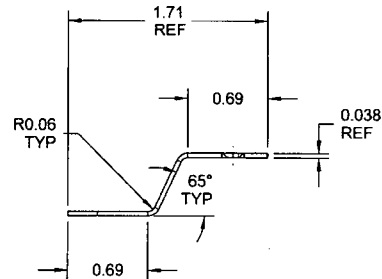
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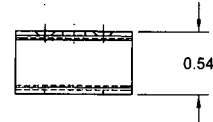
#51172
MF
09-08-6



D3934-1F FLAT PATTERN



D3934-1 CLIP
(MAKE FROM D3934-1F)



RELEASED
09/05/05 MB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
20 GAUGE (0.038 THICK)
REF DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	REV	DART AEROSPACE LTD	
DRAWN	REV	HAWKESBURY, ONTARIO, CANADA	
CHECKED	REV	DRAWING NO.	REV. A
MFG. APPR.	REV	D3934	SHEET 2 OF 2
APPROVED	REV	TITLE	SCALE
DE APPR.	REV	CLIP ASSEMBLY	NTS
DATE	09.04.16	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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